Work Orde  July-23-13 1:13		5108		*105	108*							Page 1
Item ID: Revision ID:	D3022-1			Accept	*N900	040	100	)*	Setup	Start Stop	1/1	S1* S2*
Item Name: Start Date: Required Date: Reference:	7/23/13 : 7/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item   Customer:	ID:					IV	5/
Approvals:		an: MLJ	Date: \( \frac{13-07-2}{2} \)	Tooling: SPC (Y/N):		ate:			Run	Start Stop	IN	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3022	Rev	/ B										
*100  *100* Waterjet FLOW CNC Water	jet	FLOW WATER JET  Memo  1-Cut as pe  Dwg Rev:_	r Dwg D3022	0.00						ป		<u>de</u> 13.10.01
		Prog Rev:_ *** grind	direction along 31.700" *** ES,TRANSFER DRILLED									
*110 *110* QC		QC2- Inspect parts off r	nachine FAI/FAIB	0.00						o		<u>Ae</u> 13.10.01

Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: DISPOSITION **AGAINST DEPARTMENT/PROCESS** Work Order: Skid-tube Crosstube Water Jet Engineering Rework Prod. Eng. Coor. Part No. Machining Small Fab Quality Scrap Use-as-is Thermoforming **Finishing** Rec/Store/Packaging Other Supplier NCR No. Work Order Update Large Fab Composite Description of work order update Initial Action Sign & Root Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other

			FAU	ILT CATEGORY		
Land	ing Gear	General	i.			
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Γ	Maintenance	Part Moved	<del></del>
	Heat Treat	Countersink	Г	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	<u> </u>	Offset	·	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Wave/Twist in Tube

Process Supplier Training Unapproved

Quality Control

Work Ord July-23-13 1:1		05108		*105	5108*						Page 2	<u>;</u>
Item ID: Revision ID: Item Name:	D3022-1 Seat Pan			Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Star Stop	IA	S1* S2*	
Start Date: Required Date Reference:	7/23/13 :: 7/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Stop	,I <i>Z</i> I	R1* R2*	
Sequence ID/ Work Center I 120 *120* QC Quality Control	ID	Operation Description QC8- Inspect parts - second	ond check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.	
130 *130* Brake NC Brake NC		Bend as per dwg  Memo		0.00							Si 	3 3 bo/01
140 *140* QC		QC5- Inspect part comp	leteness to step on W/O	0.00				0	13-15	o <u>. Ol</u>	<b>D</b>	

							-					DQA:	•	Date:		
NCR:	es /	No				WORK ORDER NON-C		NFORN	AANCE / UP	DATE	(	QA Closed:		Date:		
					,	DISPOSITION				A CAINST D				oute.		•
Work Orde	er:					DISPOSITION				AGAINST D	IEP.	AK I IVIEN I /	PROCESS			
Part N	No					Rework Scrap Use-as-is		N	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water J d. Eng. Cod e/Packagi	or.	Engineering Quality Other	
NCR N	No	10-1-2-1-1-1			·····	Work Order Update			Large Fab	Composite		·	Suppli			
Root					Descri	ption of work order update	I	nitial	Ac	tion		Sign &				•
Cause		ate	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	┙	Date	Verifica	ion	QC Inspector	
Doc/Data																
Equip/Tooling						·					1					
Operator											1					
Material					:						1					
Setup																
Other	Ш			_							1					
Process							1									
Supplier							ł			•						
Training																
Unapproved	<u> </u>						<u> </u>									_
					·	F/	AUL	T CATE	ORY							-
Landi	ng Gea					General		1		_	_				1 ·	
		nding				Bend		Grain		ļ		Ovalized			Pressure/Forced	
	Ce	ntre No	t Concer	ntric to	o/s	BOM/Route	Ш	Hardwa	_	<u> </u>	ا_	Over/Under	tolerance		Temperature/Cure	
	igaplus	icks				Broken/Damaged		ł i	on Incomplete			Part Incorrec		_	Weld	
	$oldsymbol{oldsymbol{ o}}$		Crimped			Burrs		4	ons Incomplete/	Unclear	_	Part Lost/Mis	ssing		Wrong Stock Pulled	
	Cu	ffs				Contamination		Mainte	nance	L	╝	Part Moved				
	<u></u> Не	at Trea	t			Countersink		Mislabei	led		_ F	Positioned W	/rong		•	
	line	nection	Strin in	Tuhe	[	Cut Too Short	1	Misroad			Ic	Dower Loss/9	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ord</b> <i>July-23-13 1:13</i>		05108	4	*105	5108*							Page 3
Revision ID:	D3022-1 Seat Pan			Accept	*N900	<b>040</b>	100	<b>)</b> *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	7/23/13 7/23/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	<b>D:</b>				<b>.</b>		
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:		. 1		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	)	Operation Description Identify as per dwg & St	ock Location: WAS	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Iumber	Insp. Stamp
*200* Packaging		Мето	7	0.00					13.	-10-9	0L	<u>D</u>
210		QC21- Final Inspection	- Work Order Release	0.00					10/2	] [] []	2_//	n-2
*210*.		Memo		0.00				-7	X //U		5-10	

Quality Control

												DQA:	Da	ite:	
NCR: Y	/es	/ No				WORK ORDER NON-C		NFORN	AANCE / UPI	DATE		QA Closed:		ite:	
Work Orde	or:					DISPOSITION				AGAINST D	Ε	PARTMENT	PROCESS		
Part N	- ۱٥٠					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Act	tion	_	Sign &			
Cause		Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landi					r	General	_	1 _		<b>[</b>		1			l
		Bending			ļ	Bend		Grain		1		Ovalized		<u></u>	Pressure/Forced
	_	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa				Over/Under		$\vdash$	Temperature/Cure
	-	Cracks				Broken/Damaged	_	4	on incomplete	. L	_	Part Incorred		<u> </u>	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs		-1	ions Incomplete/	Jnclear	_	Part Lost/Mi	ssing	L	Wrong Stock Pulled
	Щ	Cuffs			_	Contamination	<u> </u>	Mainte		_		Part Moved			
		Heat Trea	-			Countersink	<u></u>	Mislabe		L		Positioned V	-	_	Ī
		Inspection	n Strip in	Tube		Cut Too Short	<u>L</u>	Misread	1			Power Loss/:	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

## **Picklist Print**

July-23-13 1:13:15 PM

Work Order ID:

105108

Parent Item:

D3022-1

Parent Item Name:

Seat Pan

**Start Date:** 7/23/13

Required Date: 7/23/13

Page 1

Start Oty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23Revised NG

IPP Rev:D 08-04-16 now water jet DD verified by:EC
IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	607.0412	1.6232	1.708631	6	te 1	3.10.0
	*			<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT022		607.0412			<del></del>				
				11824	13	32.3562				·····			
				11852	23	141							
				12130	)9	68.656	•						
				12309	96	27.6				<u></u>			
				12357	74	81.9							
				12498	37	255.529			12	4987 -	1 ک	71	

													DQA:	Dat	e: _	
NCR: Y	'es	/ No					WORK ORDER NON-O	100	NFORI	MANCE / UP	PDATE	(	QA Closed:	 Dat	:e:	· · · · ·
Work Orde	ò.		,				DISPOSITION		·		AGAINST D		<del></del>	<del></del>		
Part N	lo.						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	rip	tion of work order update		nitial	Ac	ction		Sign &		П	
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	<u>.  </u>	QC Inspector
oc/Data quip/Tooling Operator Material etup Other rocess upplier raining									·							
							F	AUL	T CATE	GORY			14 148 188 18			
Landi	ng (	Gear			_		General	_								
		Bending Centre No Cracks Crushed/o Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in i Bend	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing (		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S	equence				Finish		Out of S	Sequence		_				

Outside Dimensions

Wave/Twist in Tube

Folio

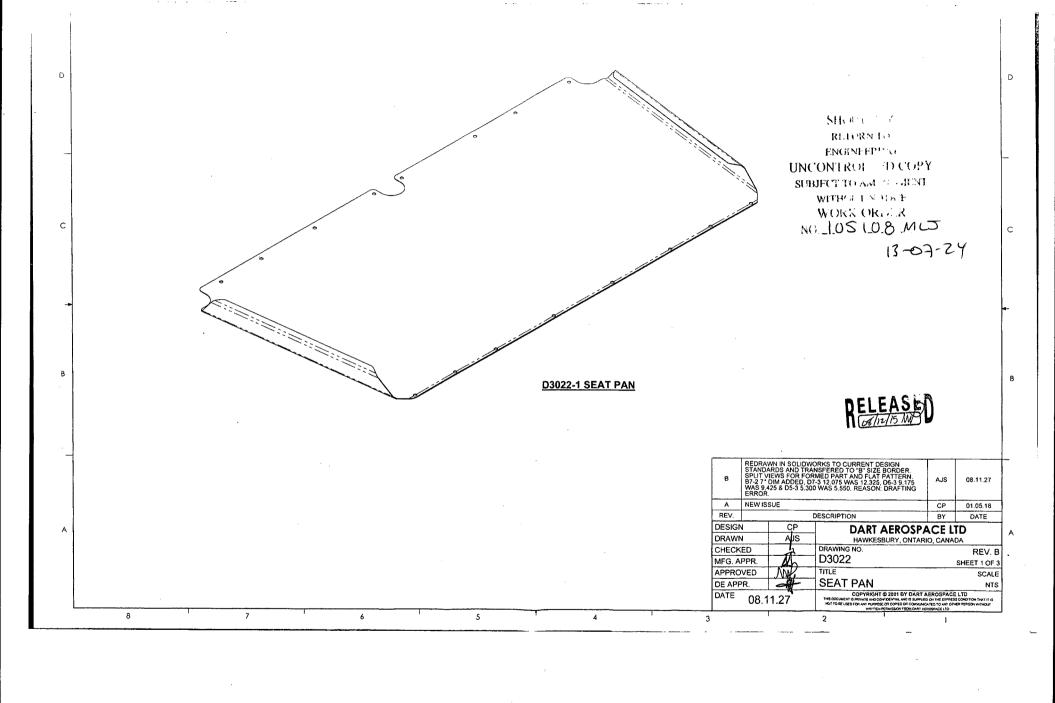
DART AEROSPACE LTD	Work Order: 105108
Description: Seat Pan	Part Number: D3022-1
Inspection Dwg: D3022 Rev: B	Page 1 of

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.75	+/-0.030	14.75	_		T	JKM-UB
12.28	+/-0.030	12.28	-		Τ	01. 00
2.72	+/-0.030	2.72	_		V	JKm-01
14.62	+/-0.030	14.62	_		T	
12.15	+/-0.030	12.15			ſ	
•						
					·	
					<del></del>	
·						

Measured by: Ac	Audited by:	13.10.01	Preliminary Approval:	,
Date: 13.80.01	Date:	PD	Date:	

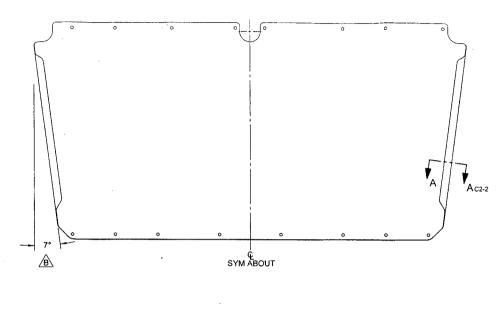
Rev	Date	Change	Revised by	Approved
A	08.06.13	New Issue	KJ/DD IN	11/
В	11.06.21	Dwg Rev updated	KJ KJ	
			1/1	



D

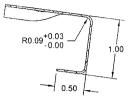
С

В

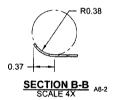




D3022-1 SEAT PAN B



SECTION A-A C4-2



DESIGN	CP	DART AEROSPACE LTD		
DRAWN	AUS	HAWKESBURY, ONTA		
CHECKED	15	DRAWING NO.	REV. B	
MFG. APPR.	M	D3022	SHEET 2 OF 3	
APPROVED	MA	TITLE	SCALE	
DE APPR.	- 41	SEAT PAN	NTS	
DATE 08.11.27		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUP	COPYRIGHT © 2001 BY DART AEROSPACE LTD  THIS DOCUMENT IS SHEWATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EPPRESS CONCINON THAT IT IS  AND TO BE LISTO FOR ANY HUMORS ON COPPIDED ON COMPANIENTED TO ANY OTHER PERSON WITHOUT	

D

NOTES:
1) MATERIAL: MAKE FROM D3022-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.36 lbs

8

